

Work Order ID 57076

Saturday, March 20, 2010 9:50:55 AM

Page 1

Item ID: D3915-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Light Lid ass'y, Long lid

Start Date: 3/22/2010 Start Qty: 1.00

Required Date: 3/31/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 10-3-20

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3915

PA/ Rev A 10.04.01

100

Weld per dwg A/R Aluminum rod Batch:

0.00



Large Fab

4112860

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D3915
****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE
A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID
FRAME****
2- weld hinge, label plate and Mounting plates as per dwg D3915

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PRELIMINARY

10/04/01

(12)

PD 10.04.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 10/04/02
checked to Reelers Day Rev A.

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

ENSURE TO RINSE CAREFULLY ACID AND ALODINE

m. h 10/04/02 (IX)

140

Weld per dwg A/R Aluminum rod Batch: 0.00



Large Fab

Memo

0.00

Large Fab

1- weld (4) corners

m108436

10.04.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

150.A - QC6 inspect F.H. of LD. - ~~ES~~ Solubility
Fit is next to perfect.

PD 10.04.04

P10 →

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

M11B170.

0.00

Powder Coating

1- touch up corner with alodine only
2- Plug holes prior to

1ST COAT:

START TIME: 8:20

OVEN TEMPERATURE: 320°

FINISH TIME: 8:50

***** 2nd coat if necessary *****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____


FINISH TIME: _____

3 N/A

OK 10-4-5

Q.

Dart Aerospace Ltd

W/O: 57076		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/04/04	#150.1	ADD Qc 6 to insert Fit of L.D		10.24.07			8 10/04/12

Part No: D3915-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 3/22/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 3/31/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

88 12/24/05 ① ②

180

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

1- Install webbing as per dwg

2- Install placard and label as per dwg

83 10/04/06 ①

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 10/04/06
to Rev A Dwg

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 57076

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Start Date: 3/22/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 3/31/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

u/o 57139

10/04/06

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/06

POSITIVE RECALL

EFFECTIVE

RELEASED

AUTH

DATE

MF 10-4-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Saturday, March 20, 2010 9:50:55 AM

Work Order ID: 57076

Parent Item: D3915-041

Parent Item Name: Light Lid ass'y, Long lid

Start Date: 3/22/2010

Required Date: 3/31/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2957 Mounting Plate		Manufactured	No			100	Each	6.0000	4.0000			

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

WA

6

29869

2

36399

1

56660

3

B357088 → (4x) SH 10/04/01

D3915-1
Rib

Manufactured

No

100

Each

0.0000

2.0000

Polem

B357089 → (2x) SH 10/04/01

D4016-5

Manufactured

No

100

Each

6.0000

3.0000

Polem

B356075 (3x) SH 10/04/01
~~B357090 (3x)~~

Hinge Half, Light Lid

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

ENG

6

56075

6

D4019-3

Manufactured

No

100

Each

0.0000

3.0000

" Rev A "

B357090 (3x) SH 10/04/01

Rib

D4035-045

Manufactured

No

100

Each

0.0000

1.0000

" Rev A "

B356972 (1) SH 10/04/01

Lid Rib Assembly, Fwd (Light)

D4036-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

Saturday, March 20, 2010 9:50:55 AM

Work Order ID: 57076

Parent Item: D3915-041

Parent Item Name: Light Lid ass'y, Long lid



Start Date: 3/22/2010

Required Date: 3/31/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC




Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4035-047  Lid Rib Assembly, Aft (Light)		Manufactured	No			100	Each	0.0000	1.0000			
D4056-1  Label Plate		Manufactured	No			100	Each	2.0000	1.0000			

B56977 ① SH 10/04/01

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
WA	2	
56661	2	

D2728-1  Dart Logo label		Manufactured	No			180	Each	0.0000	1.0000			
D4029-041  Webbing (Long Basket)		Manufactured	No			180	Each	0.0000	1.0000			
D4086-220  Placard, Max Load		Manufactured	No			180	Each	0.0000	1.0000			

"Rev A"

Rev A

Rev A

B56938 ① SH 10/04/01

✓ S 10/04/05 :
SA 10/04/05

B ~~56947~~ B 56963

SB 10/04/05

B 56979

①

Saturday, March 20, 2010 9:50:55 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

Saturday, March 20, 2010 9:50:55 AM

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Work Order ID: 57076



Parent Item: D3915-041



Parent Item Name: Light Lid ass'y, Long lid

Start Date: 3/22/2010

Required Date: 3/31/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS20600-AD4W3		Purchased	No			180	Each	758.0000	34.0000			
---------------	--	-----------	----	--	--	-----	------	----------	---------	--	--	--



Blind Rivet

PTD

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST321 758

110523 212

111477 546

NAS1149DN416J		Purchased	No			180	Each	0.0000	34.0000			
---------------	--	-----------	----	--	--	-----	------	--------	---------	--	--	--



Washer

M 13910

34
34

Sp 10/04/05

Saturday, March 20, 2010 9:50:55 AM

Shop Packet Print

Page 3

W/O: 57076		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		Change MS2060AD4-5 to MS2060AD4-3 M 106375 Permanent Change <i>(10.04.07 can not change as per part list)</i>	EP	10/04/05	34	<i>(Signature)</i>	<i>(Signature)</i> 10-04-05	
		<i>(Signature)</i> Tried one AN960SD6 M104537 one MS2060AD4-4 M113368 okay to leave in basket lid	SA	10/04/05	1	<i>(Signature)</i> 29/04/05	<i>(Signature)</i> 10-04-06	

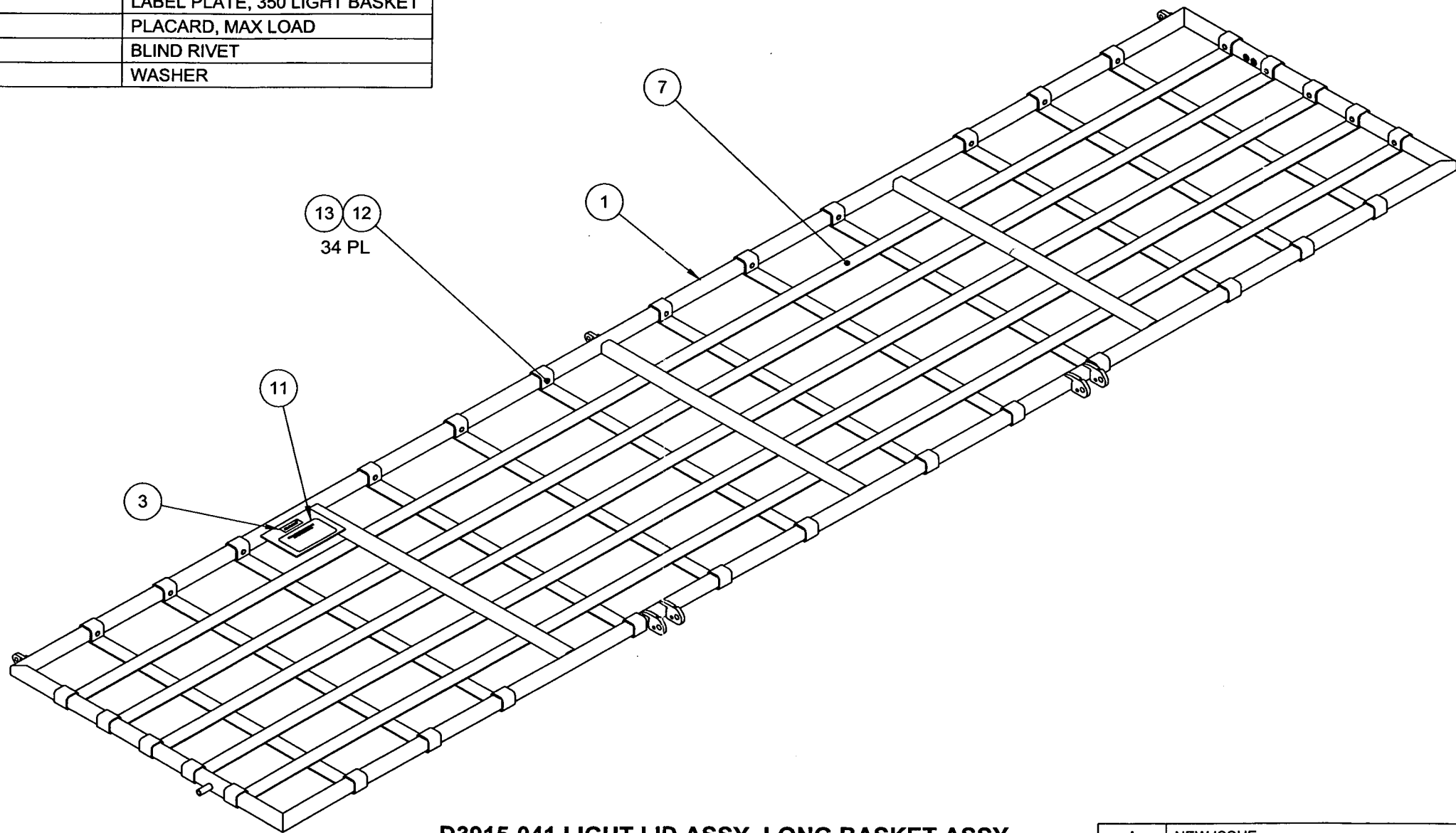
Part No: D3915-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

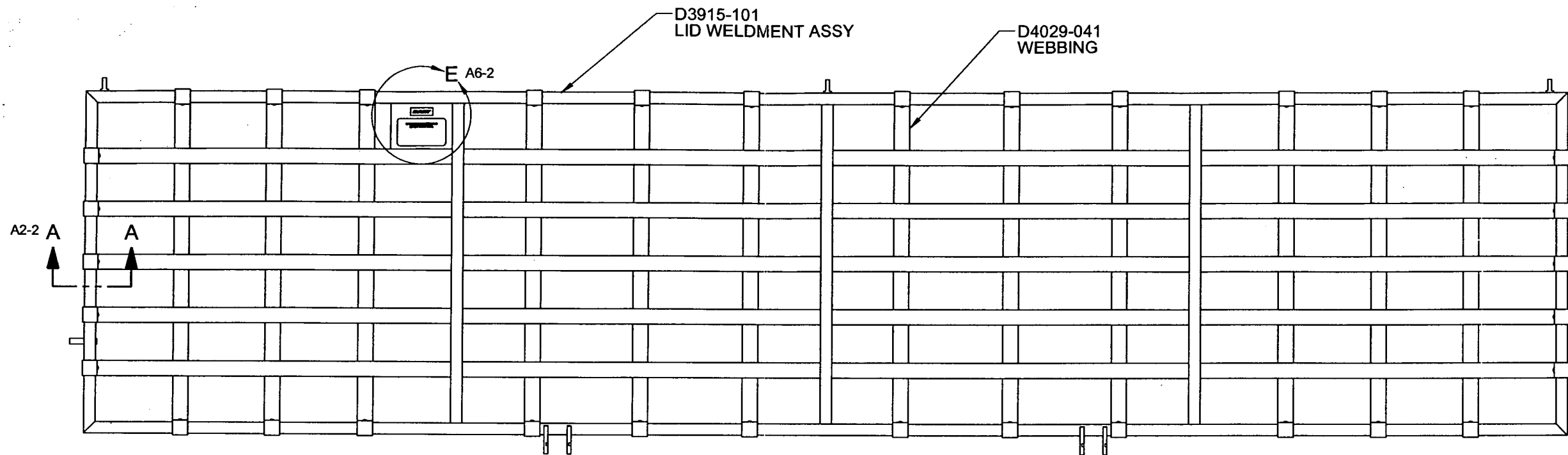
ITEM	QTY -041	QTY -101	P/N	DESCRIPTION
	X		D3915-041	LIGHT LID ASSY, LONG BASKET
1	1	X	D3915-101	BASKET LID WELDMENT ASSY
2		2	D3915-1	RIB
3	1		D2728-1	DART LOGO LABEL
4		4	D2957	MOUNTING PLATE
5		3	D4016-5	HINGE HALF
6		3	D4019-3	RIB
7	1		D4029-041	WEBBING (LONG BASKET)
8		1	D4035-045	LID RIB ASSY, FWD
9		1	D4035-047	LID RIB ASSY, AFT
10		1	D4056-1	LABEL PLATE, 350 LIGHT BASKET
11	1		D4086-220	PLACARD, MAX LOAD
12	34		MS20600AD4W5	BLIND RIVET
13	34		NAS1149DN416J	WASHER



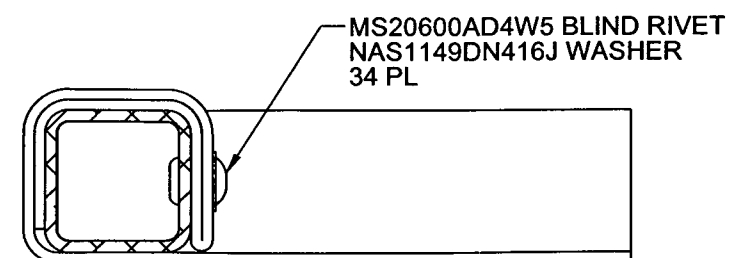
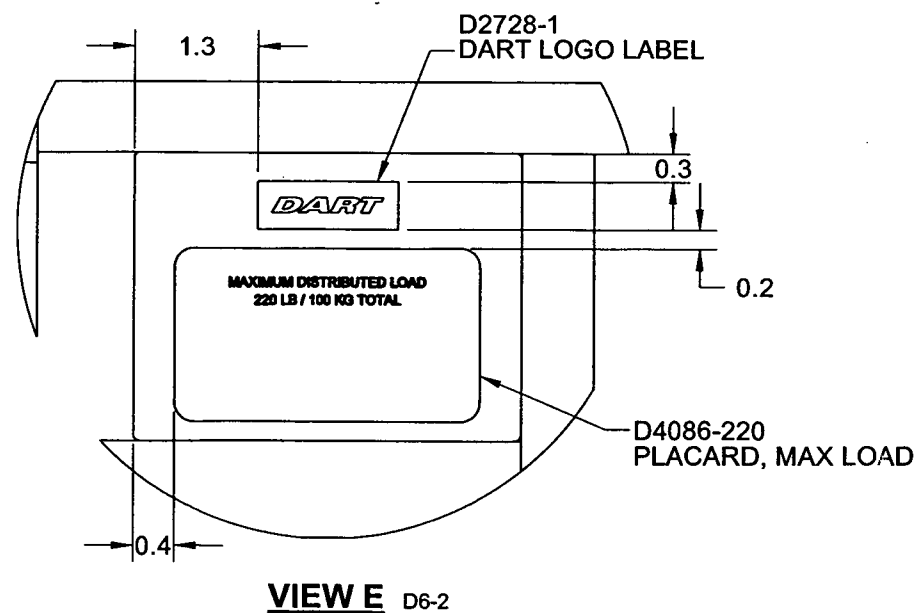
D3915-041 LIGHT LID ASSY, LONG BASKET ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 6.91 lbs

A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3915	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID ASSY-LONG BASKET	
DATE	10.03.16	<small> COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>	



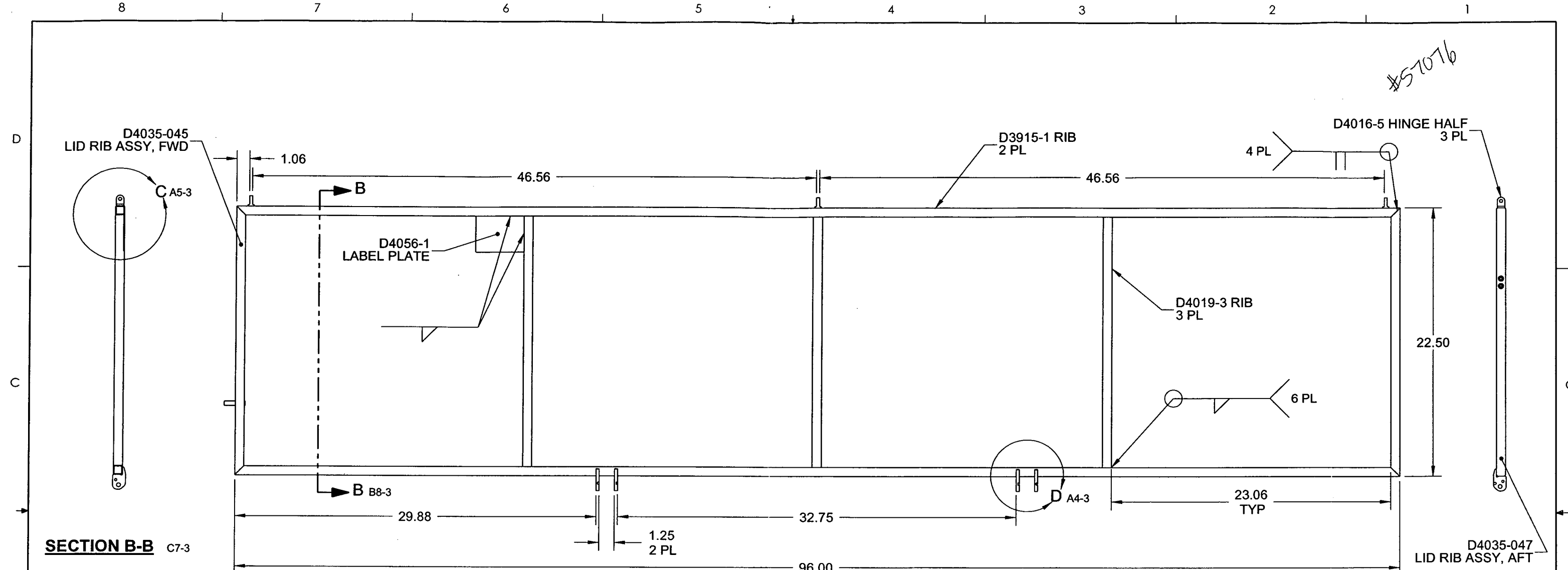
D3915-041 LIGHT LID ASSY, LONG BASKET



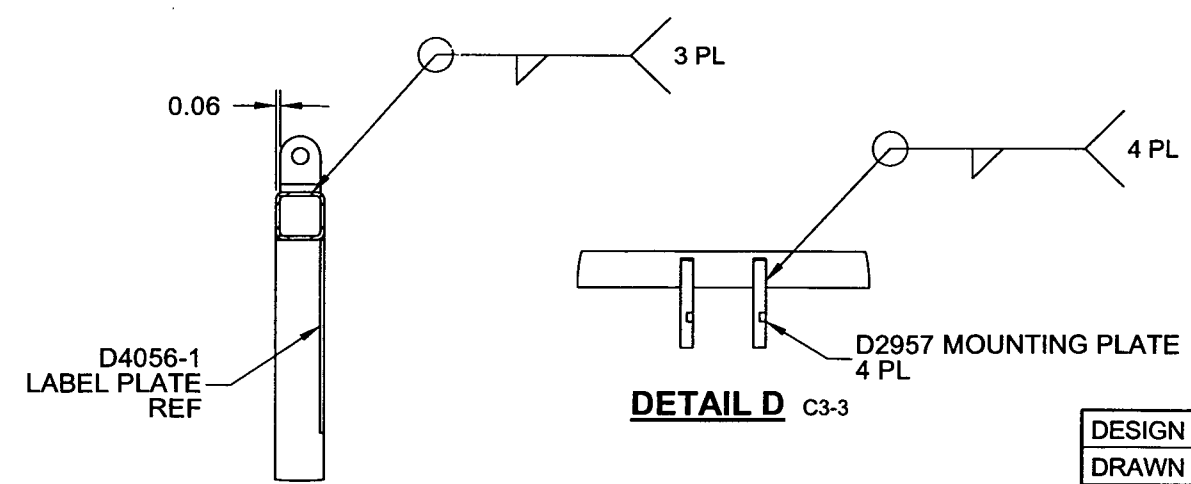
SECTION A-A C8-2

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3915	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID ASSY-LONG BASKET	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3915-101 BASKET LID WELDMENT ASSY ASSY



- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 4.81 lbs
 - 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3915	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID ASSY-LONG BASKET	NTS
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RELEASED
2010-03-22